

Work Order ID 130027

February-23-15 10:38:10 AM

130027

Page 1

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 2/18/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1502-26 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3886	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	FLOW WATER JET								
304.100"	1-Cut as per Dwg D3886-3								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(4)

DC 15/03/07

(4)

DC 15/03/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Page 2

MAR 31 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 131545</i> Memo	0.00 <i>START: 10:00</i> <i>0.00</i> <i>OVEN. T: 400°</i> <i>FINISH: 10:30.</i>				<i>H</i>	<i>Ø</i>	<i>15-5-6</i>	<i>DAS</i> <i>38</i> <i>3 29</i>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(4)</i>	<i>FF</i>		<i>DAS</i> <i>38</i> <i>3 29</i> <i>MAY 06 2015</i>
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>st 529</i> Memo	0.00 0.00				<i>Y</i>	<i>DAS</i> <i>27</i> <i>3-29</i>		<i>MAY 07 2015</i>

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MCS MAY 07 2015

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Picklist Print

February-23-15 10:38:10 AM

Page 1

Work Order ID: 130027

130027

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 2/18/15

Required Date: 2/23/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

100

sf

90.7813

0.1472

0.5888

M304S12GA

304/316 0.100" Sheet

DL15/03/07

Location

Loc Qty

Loc Code

MAT019

90.7813

m131322

90.7813

D3886-1

Manufactured

No

150

Each

12.0000

1

4

D3886-1

Lug

EL 15-4-15

Location

Loc Qty

Loc Code

WA002

12

124402

12

131067 x 2

2

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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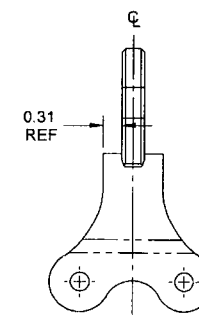
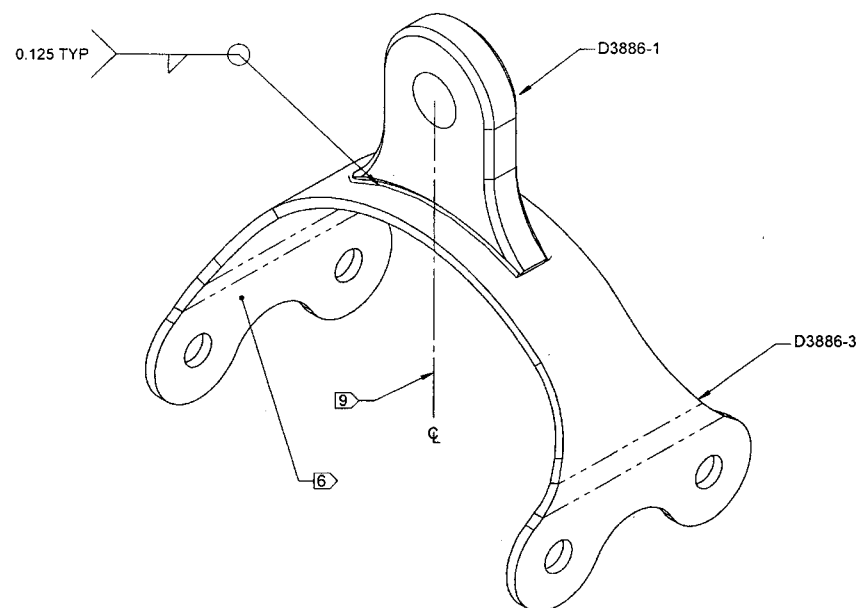
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



D3886-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

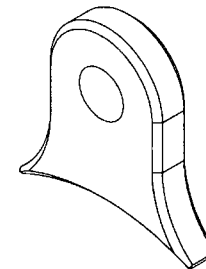
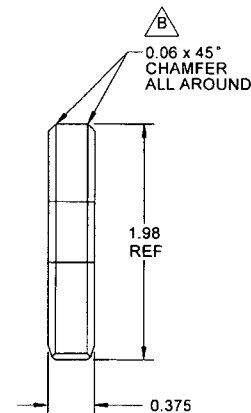
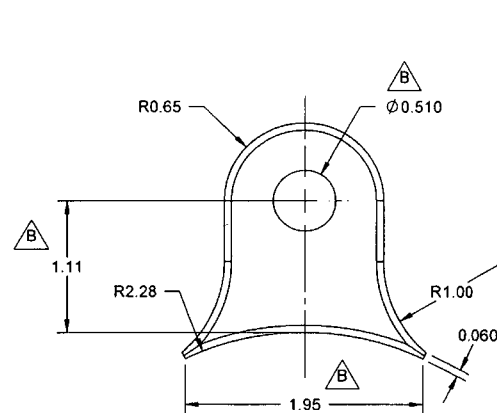
B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.08.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3886** REV. B
SHEET 1 OF 4
TITLE **LUG ASSEMBLY** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

130027 MJS
1502-26 RELEASED
09/07/09



D3886-1 LUG (B)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

RELEASED
09/07/05

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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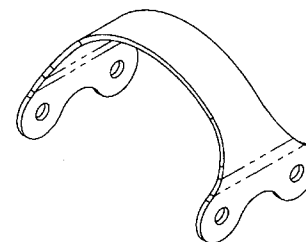
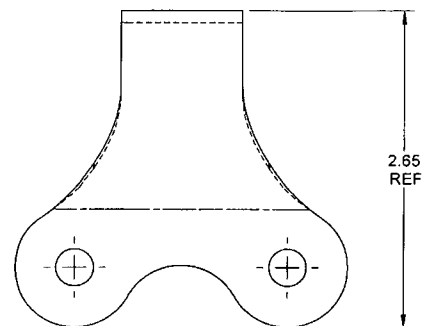
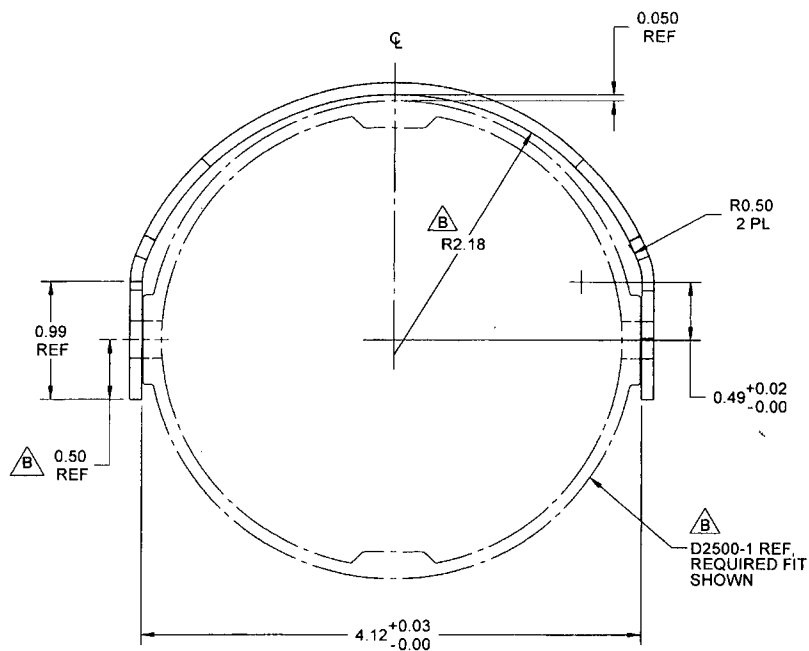
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D3886-3 BRACKET
(MAKE FROM D3886-3F)

RELEASED
06/15/08

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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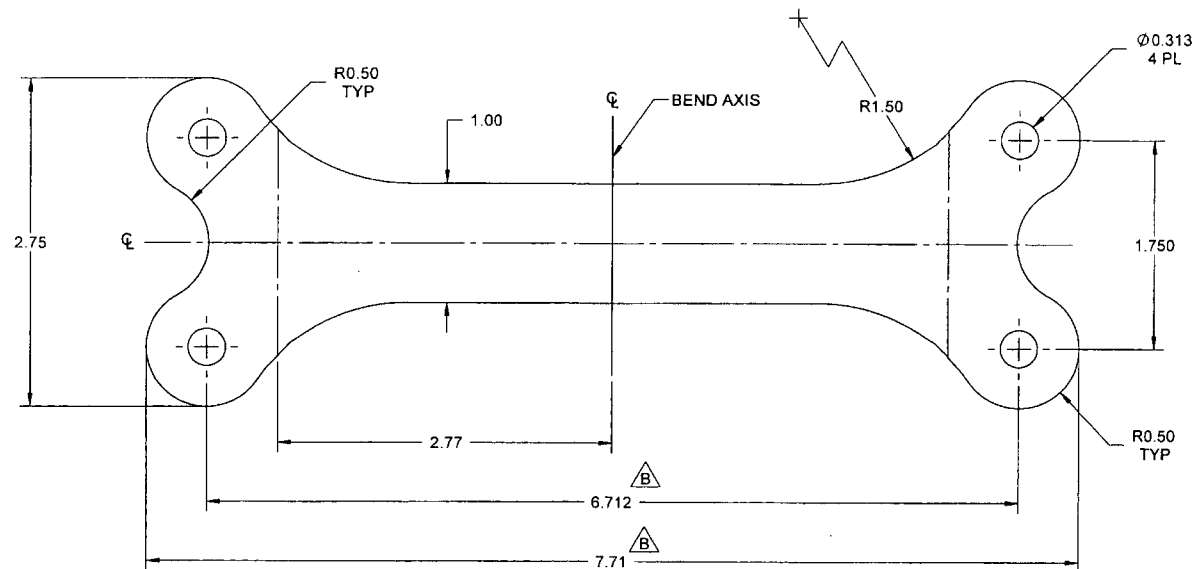
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D3886-3F FLAT PATTERN B

RELEASED
9/27/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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